

Work Order ID 86654

86654

Page 1

July-06-12 11:12:59 AM

Item ID: D3023-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Back Panel
 Start Date: 7/06/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/06/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: Date: 12-07-16 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr					①			
D3023	Rev A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3023								
<u>2074 . 032</u>	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	***graind direction along 28.100" ***								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

B12-7-29

B12-7-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 <i>SMB</i> 12-7-25 0.00	<i>DAS</i> 16 9-53	<i>12/4/25</i>		<i>①</i>			
130 *130* Brake NC Brake NC	Form as per dwg Memo	0.00 0.00				<i>①</i>			<i>S</i> <i>12/6/25</i>
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	<i>DAS</i> 13 12-4-25	<i>12/4/25</i>		<i>④</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

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Required Date: 7/06/12 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: _____	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12/2/2012
MLJ 12/07/26
MLJ 12/07/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-06-12 11:12:58 AM

Page 1

Work Order ID: 86654

Parent Item: D3023-1

Start Date: 7/06/12

Required Date: 7/06/12

Parent Item Name: Back Panel

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C02.01.23Revised NG
IPP Rev:D 08-04-16 now water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032 2024-T3 .032 sheet		Purchased	No			100	sf	183.2481	2.8777	3.0291579			

18 12-7-29

Location	Loc Qty	Loc Code
MAT022	183.2481	
118243	16.2481	
118523	73	
121309	94	

121309

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	96654
Description: Back Panel		Part Number:	D3023-1
Inspection Dwg: D3023	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

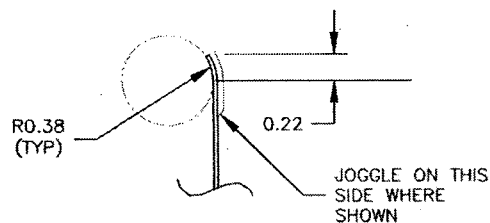
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.128	2		V Boz	
Ø0.191	+0.005/-0.001	.192	2		V	
1.660	+/-0.010	1.666	2		V	
0.375	+/-0.010	.375	2		V	
1.340	+/-0.010	1.347	2		V	
2.375	+/-0.010	2.377	2		V	
0.375	+/-0.010	.377	2		V	
25.28	+/-0.030	25.28	1		T Boi	
27.03	+/-0.030	27.02	1		T	
28.10	+/-0.030	28.10	2		T	
1.30	+/-0.030	1.305	2		V	
2.375	+/-0.010	2.379	2		V	
8.711	+/-0.010	8.711	2		PROUSOR	
5.597	+/-0.010	5.598	2		V	
8.57	+/-0.030	8.57	2		P	
1.970	+/-0.010	1.971	2		V	
7.42	+/-0.030	7.42	1		V	
10.92	+/-0.030	10.92	1		P	
14.75	+/-0.030	14.75	2		T	

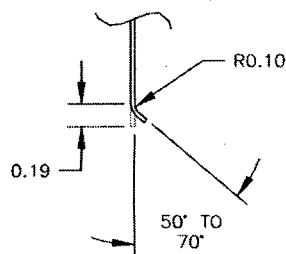
Measured by: B	Audited by: SmB	Prototype Approval:	N/A
Date: 12-7-25	Date: 12-7-25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC	

SECTION A-A
SCALE 1:1
(TYPICAL, EXCEPT WHERE SHOWN)

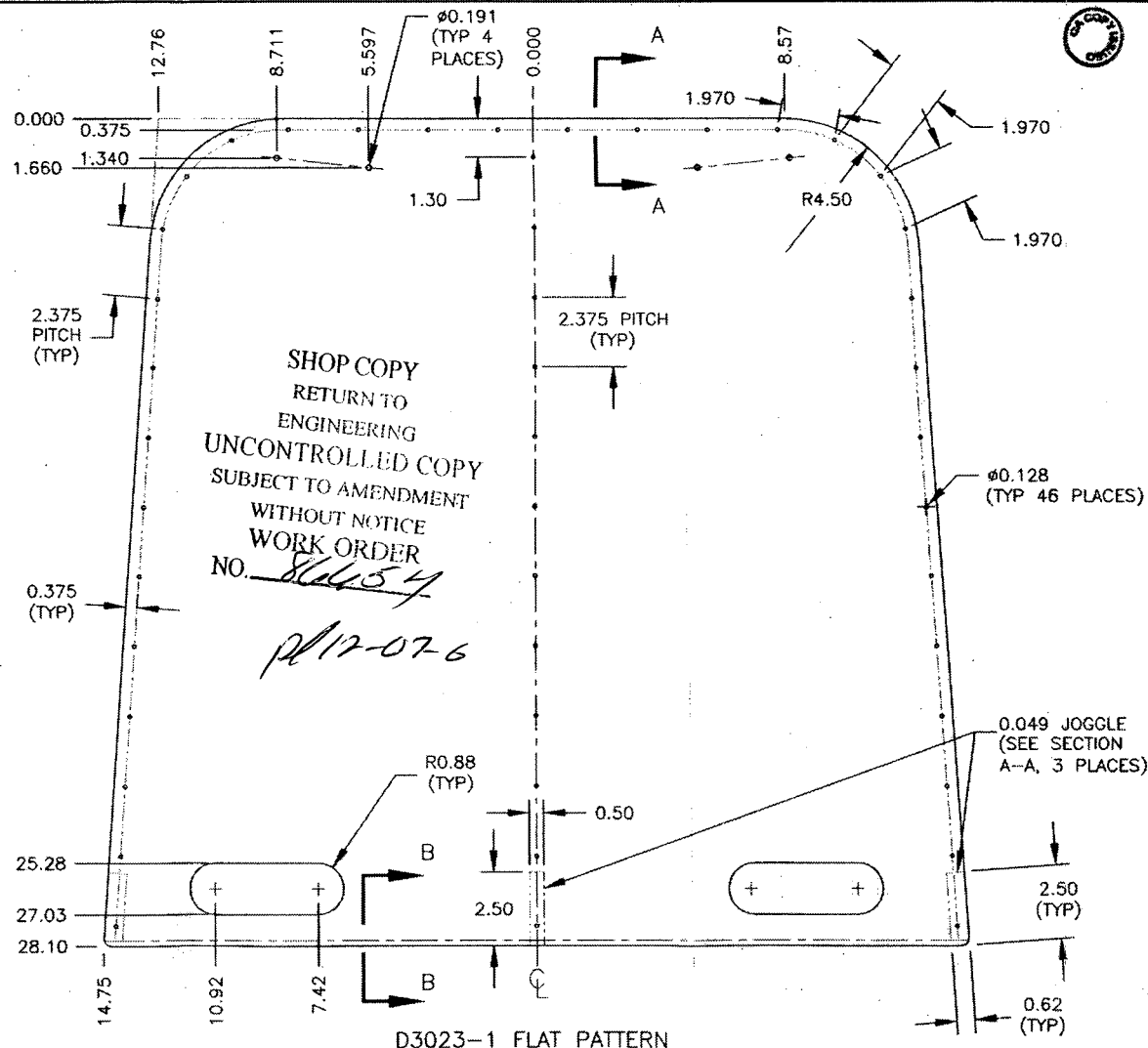


SECTION B-B
SCALE 1:1
(BOTTOM EDGE ONLY)



RELEASED
9.06.07

D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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DART AEROSPACE LTD.

A	01.05.18	NEW ISSUE
DESIGN	UP	DRAWN BY
CHECKED	4	APPROVED
DATE	01.05.18	TITLE
		BACK PANEL
		DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
		DRAWING NO. D3023
		REV. A SHEET 1 OF 1 SCALE 1:4